



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-667-207BL
Job Sheet 170522



Part No: D206-667-207BL

Job Qty: 1 ea

Part Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/29/18	1/29/18	0.00	0.00	Start Up Crosstubes-1		OPZ
110	CNC Bend Crosstubes	1 pcs	1/29/18	1/29/18	0.00	4.35	CNC Bend Crosstube		DPZ/GP
120	QC <i>see attached</i>	1 pcs	1/29/18	1/29/18	0.00	0.00	QC15		38
130	Crosstubes	1 pcs	1/29/18	1/29/18	0.00	2.86	Crosstubes-1		9-89 DPZ/GP
140	HandFXtube	1 pcs	1/30/18	1/30/18	0.00	0.55	HandFinish5		DAS 38 DPZ/GP
150	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC7-1		DAS 38
160	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC5		DAS 38
170	Outsource	1 pcs	1/30/18	1/30/18			SKY002-VC	1	13 9-89 JAN
180	Packaging	1 pcs	1/30/18	1/30/18	0.00	0.00	Packaging2		9-89
190	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC5		9-89
200	Outsource	1 pcs	1/30/18	1/30/18			ATE003-VC		PO 035886
205	Packaging	1 pcs	1/30/18	1/30/18	0.00	0.00	Packaging2		18/01/20
210	QC	1 pcs	1/30/18	1/30/18	0.00	0.00	QC14		10/18/2018
220	Crosstubes	1 pcs	1/30/18	1/30/18	0.00	2.86	Crosstubes-1		18/01/2018
230	Crosstubes	1 pcs	1/31/18	1/31/18	0.00	1.91	Crosstubes-1		18/01/2018
240	QC	1 pcs	1/31/18	1/31/18	0.00	0.00	QC5		18/01/2018
250	Packaging	1 pcs	1/31/18	1/31/18	0.00	0.00	Packaging1-2		9-89
260	QC	1 pcs	1/31/18	1/31/18	0.00	0.00	QC4		SmB
265	DC	1 pcs	1/31/18	1/31/18	0.00	0.00	DC		SmB
270	Packaging	1 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1		SmB
280	QC21-FG	1 Ea	1/31/18	1/31/18	0.00	0.00	QC21		MIS FEB 01 2018

Part Op 110 - Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207

Descriptions: 120 - QC15- Crosstube Dimensional Check

130 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: *OPZ* ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: *OPZ* ***** 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-247. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D206-667-247. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill only the top (2) holes. Drill & ream the top (2) hole

140 - Crosstubes Chemical Conversion ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

150 - QC7-Inspect Chemical Conversion Coat

160 - QC5- Inspect part completeness to step on W/O

206-667-207BL / 170522 / 5034557

DART
AEROSPACE
S034557



Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue

PART NO:
Original Serial #: D206 - 667 - 207BL
Revision:
Operation:
Change No: CHG002

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Start up Operation
CHG002

01/23/18
Job No: 170522

170 - Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Receive & Inspect for Damage & Mat'l Certs *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

190 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247

200 - ISSUE PO 39854 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

205 - Receive & Inspect for Damage & Mat'l Certs

210 - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

220 - 1-Install nut plates as per Dwg D206-667-247.

230 - 1-Abraze mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: B88708 exp 5/18 Torque bolts as per dwg 18-1-28/18-1-31

240 - QC5- Inspect part completeness to step on W/O ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

265 - Document Control Photocopy bluefile and create labels as per PPP D206-667-207 chg 002

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-667-207 Location: _____ PPP Rev: _____

280 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <u>5012189</u>	D206-667-247TRN	1	9	0	0
220-Crosstubes <u>108213-B</u>	D2873-043 <u>5034892</u>	②	1	0	0
	D2873-045 <u>5018818</u>	②	27	0	0
	MS20601-AD4W10 <u>50005539</u> <u>50197325</u>	②	223	0	0
230-Crosstubes	D2892-1 <u>5033175</u>	②	0	0	0
	D3595-063-450 <u>5033985</u>	④	23	0	0
	MS21920-22 <u>5013763</u>	⑤ → 1 scrap	126	0	0
250-Packaging	AN5-10A <u>5037856</u>	10	317	0	0
	AN5-32A <u>5037855</u>	4	154	0	0
	AN5-34A <u>5037852</u>	4	121	0	0
	MS21042L5 <u>5037843</u>	4	704	0	0
	NAS1149D0563J <u>5037848</u>	18	1,191	0	0

Part Specifications

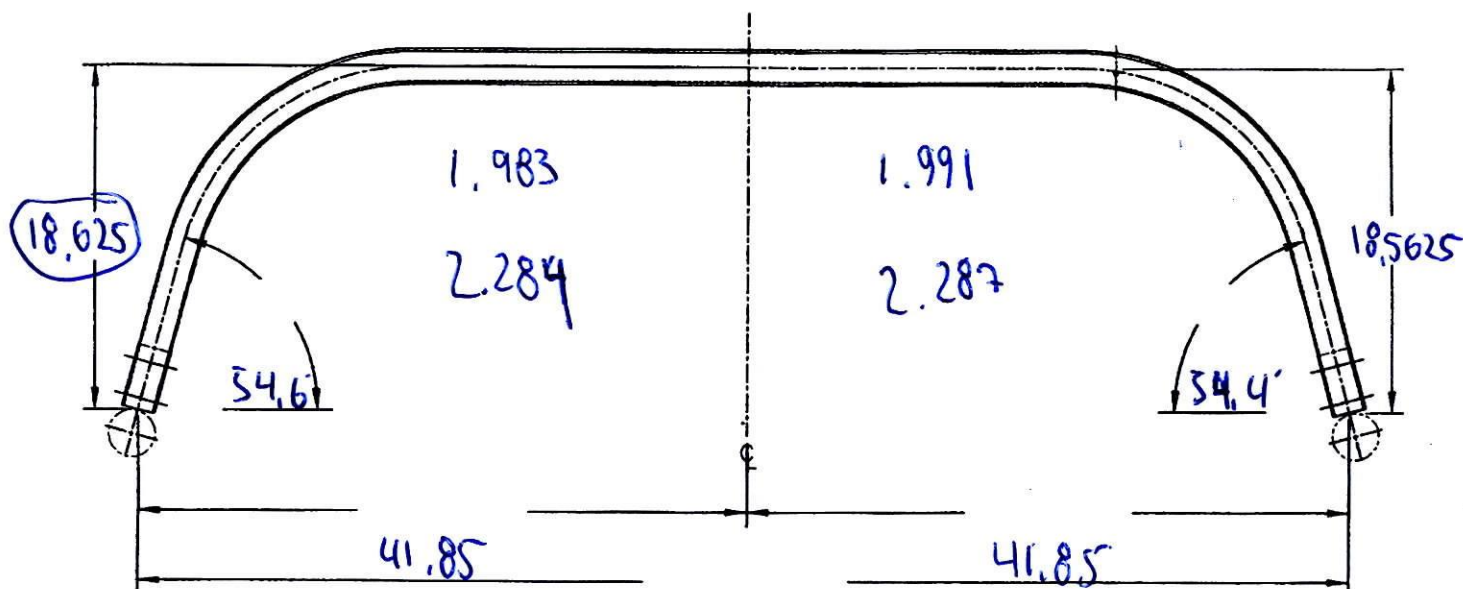
Specifications could not be found.

Plex 1/17/18 7:46 AM dart.lacelle.linda

5000199

DART AEROSPACE LTD	Work Order:	170522
Description: Crosstube Mid Aft (206L)	Part Number:	D206-667-207
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	13	12
Crushing	7.0% (circled)	6.9% (circled)
Comments		
Crushing acceptable per DR-1059 9/18/1/22		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

170522

DEO ATTACHED

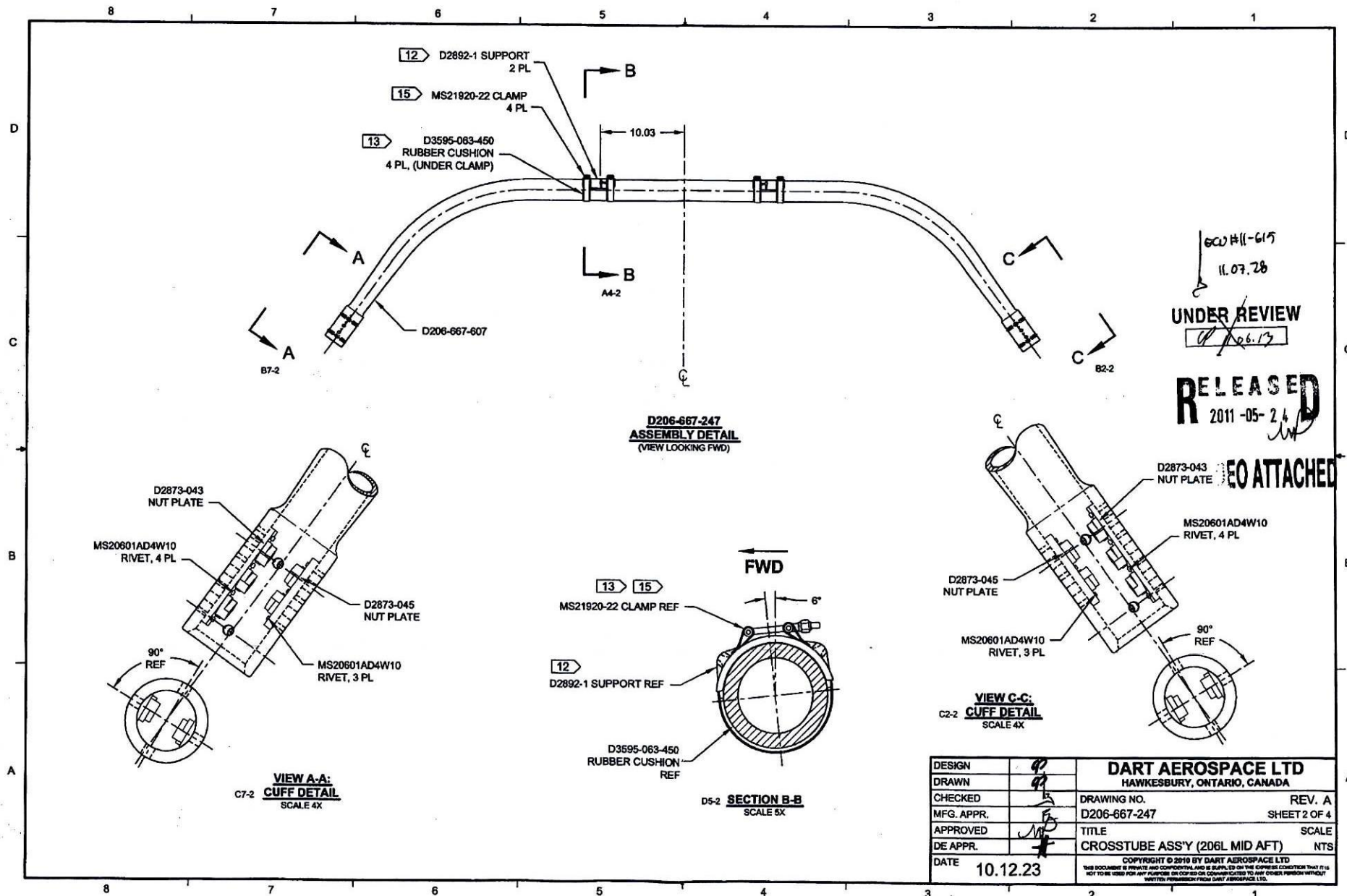
OCW #11-615
11.07.28

UNDER REVIEW

11/10/13

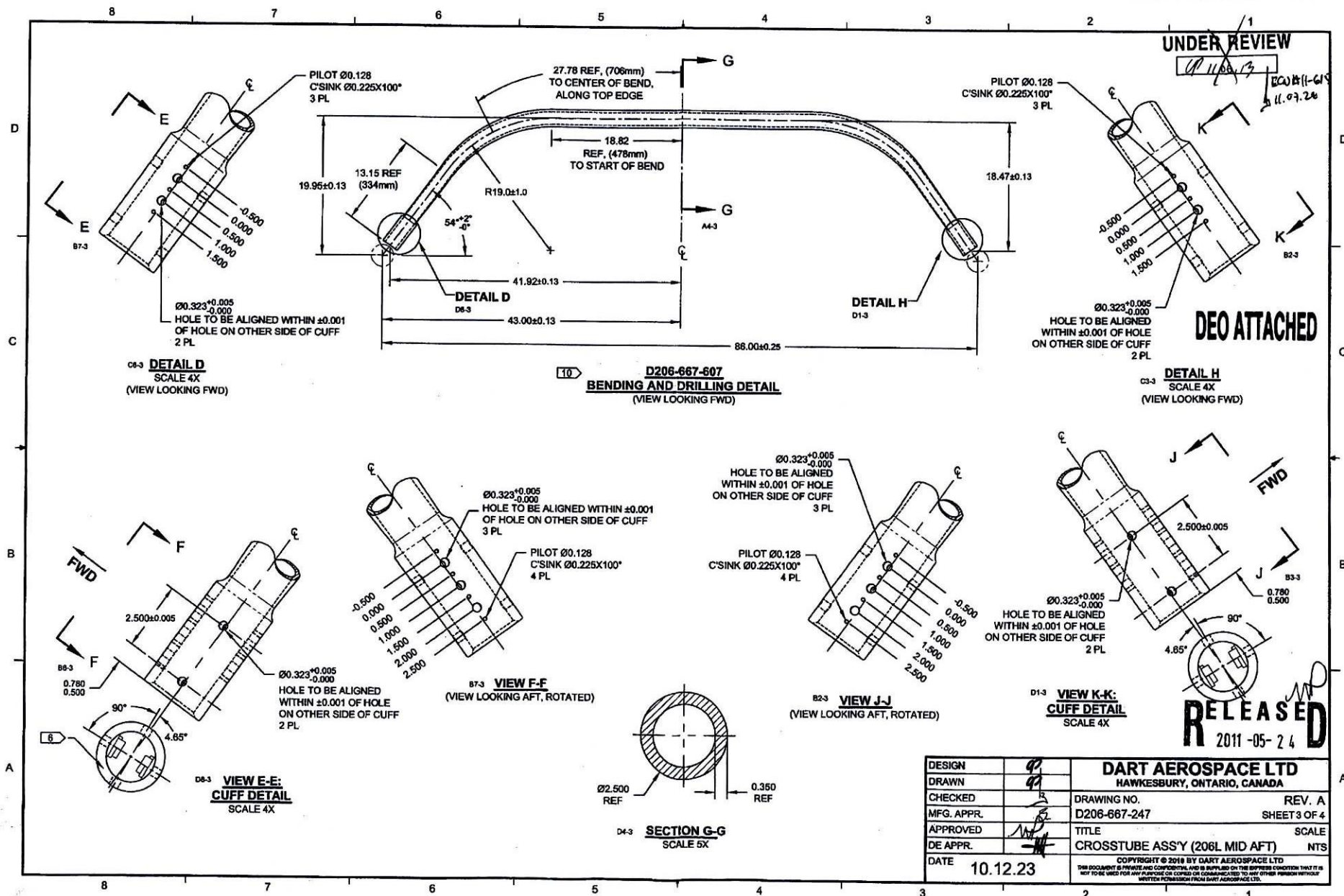
RELEASED
2011-05-24

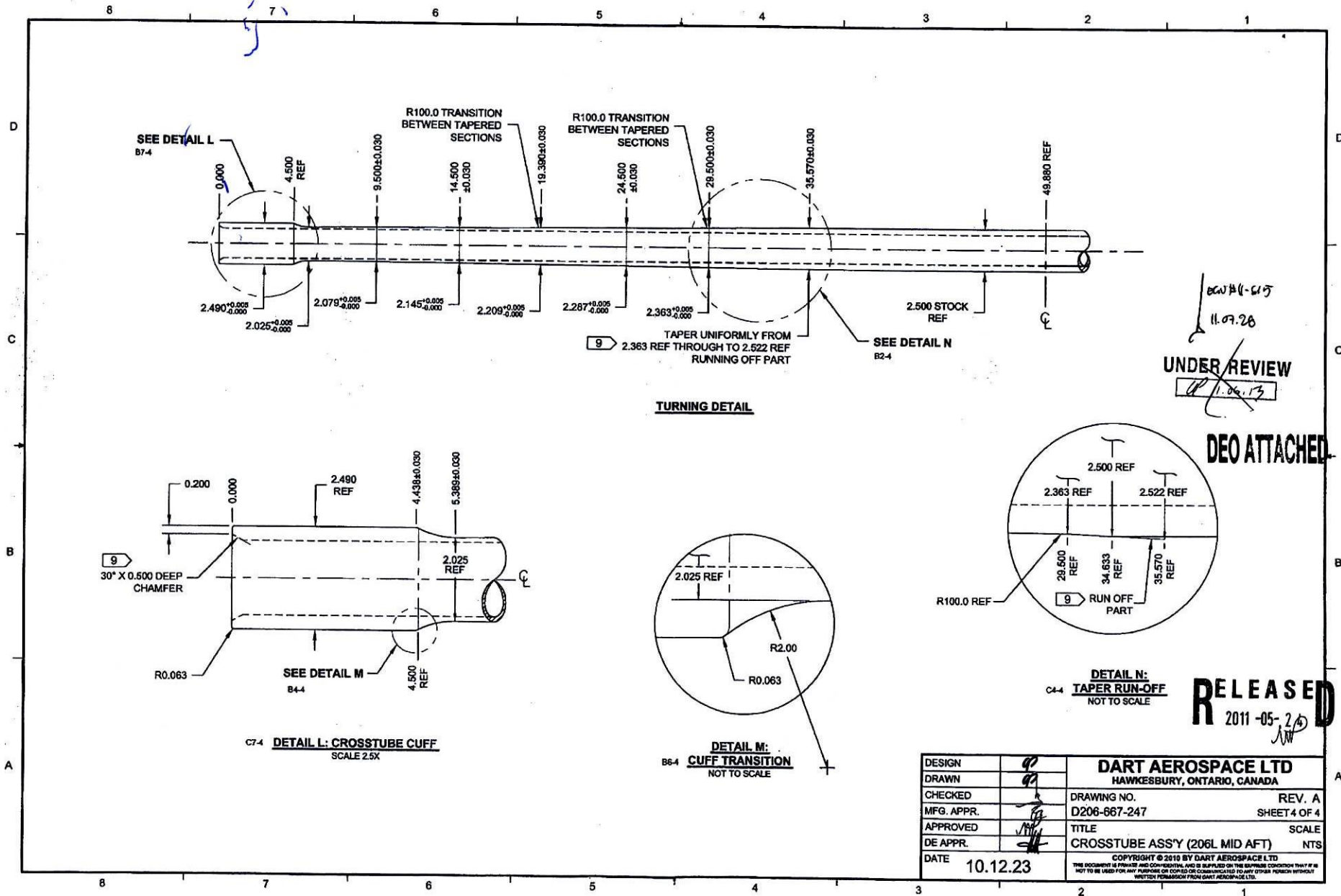
A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D206-667-247	SHEET 1 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	10.12.23	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



600 #11-615
11.07.28
UNDER REVIEW
4/26.13

RELEASED
2011-05-24
EO ATTACHED





DRAWING NO. D206-667-247	TITLE CROSSTUBE ASS'Y (206L MID AFT)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-247-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>KB</i>	APPROVED <i>WMD</i>		DE APPR. <i>#</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -247	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WMD

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**QA Closed: PD

Date: FEB 12 2018

Work Order update only ☐

Work Order: <u>170522</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>1206-667-207BC</u>		Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		Skid-tube ☐ Cross tube ☒ Machining ☐ Small Fab ☐ Thermoforming ☐ Finishing ☐ Large Fab ☐ Composite ☐							
NCR No. <u>18-6767</u>				Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐							
Date: <u>18/1/22</u>		Step #: <u>110</u>		QTY Effective: <u>①</u>		MRB (QSI042) Approval					
Description Work Order Deviation				Disposition		DAS 12 9-89 18/1/22 Completed By DAS 12 9-89 18/1/22 Lead hand / Supervisor Approval Verification PD 18-02-12 QC / QA Coordinator Approval PD 18-02-12					
After bending, one height is over tolerance by 0.025".				Acceptable. Will not cause fit issue.							
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☒	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☒	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038854**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038854
PO Date: 1/25/18
Due Date: 1/26/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166582	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
2		D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
3		D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
4	170522	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	169676	D135-1027-153	Mid Height Fwd Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
6	169662	D135-1027-253	Mid Height Aft Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
Grand Total:										\$936.86
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 1/26/18 10:44 AM dart.lavoie.chantal



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34742	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038854
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

- 1 FWD CROSSTUB , P/N# D135-1027-153 , J/S# 169676
- 1 AFT CROSSTUBE , P/N# D135-1027-253 , J/S# 169662
- 2 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 166582 , 166585
- 2 AFT CROSSTUBES , P/N# D206-667-207BL , J/S# 170521 , 170522
- 1 UPPER END , P/N# SWA6A-100
- 1 LOWER END , P/N# SWA6A-200
- 1 BEARING HOUSING , P/N# SWA6A-300
- 2 SEMI RINGS , P/N# SWA6A-500
- 1 COLLAR , P/N# SWA6A-600

Action Taken:		Date:	Initial/Stamp:		
LPI AND MPI C/O IAW ASTM E-1417M-13 & E-1444M-12 DE-MAGNETIZED AS PER ASTM E-144494-A NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142 PARKER PROBE S/N 18163 , CAL. DUE 17/FEB/2018, CARRIER, MPO17874		JAN 25 2018	 		
Description	Location P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		JAN 25 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038886

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038886
PO Date: 1/26/18
Due Date: 1/26/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166582	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____ **MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	166585	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____ **MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
3	170521	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO *** WEAR LATEX GLOVES WHEN HANDLING	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038886

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
4	170522	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:									\$900.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.